

Work Order ID 108575

Tuesday, October 22, 2013 10:40:17 AM

108575

Page 1

Item ID: D2281

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Jack Saddle

Stop

NS2

Start Date: 10/22/2013 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/1/2013 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MF

Date: 13-10-22 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Date:	Run	Start	Stop	Insp. Stamp
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D2281

Rev G

100

100

Waterjet

FLOW CNC Waterjet

304.080

FLOW WATER JET

Memo

0.00

20 0

Jm 13-10-22

I-Cut as per Dwg D2281 Dwg Rev: G Prog Rev: G 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

20 0

Jm 13-10-22

110

QC

Quality Control

Memo

0.00

120

QC8- Inspect parts - second check

0.00

DAS

27

4-89

120

QC

Quality Control

Memo

0.00

13 10 22

20

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Required Date: 11/1/2013 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00			DAS 30 9-89				
	Memo	0.00			N/A				
	Deburr								
140 *140* Brake NC	NC BRAKE	0.00							13/10/24
Brake NC	Memo	0.00			DAS 30 9-89				
	Form as per D2281 using D2281-T2								
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00			20				
			20						
			B1024						

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20

Cust Item ID:

Required Date: 11/1/2013 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: WA001

0.00

160

Packaging

Packaging

0.00

20

13-10-29

MAL

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Quality Control

Memo

0.00

AM / 13/10/30MK
13-10-29

Picklist Print

Tuesday, October 22, 2013 10:40:15 AM

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Work Order ID: 108575

Parent Item: D2281

Parent Item Name: Jack Saddle

Start Date: 10/22/2013

Required Date: 11/1/2013

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B 06.07.17 waterjet EC

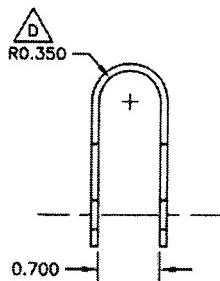
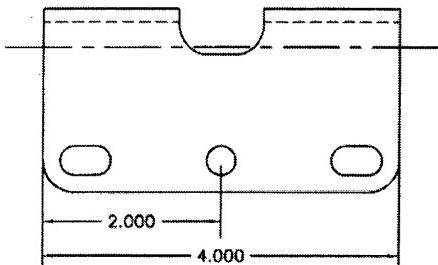
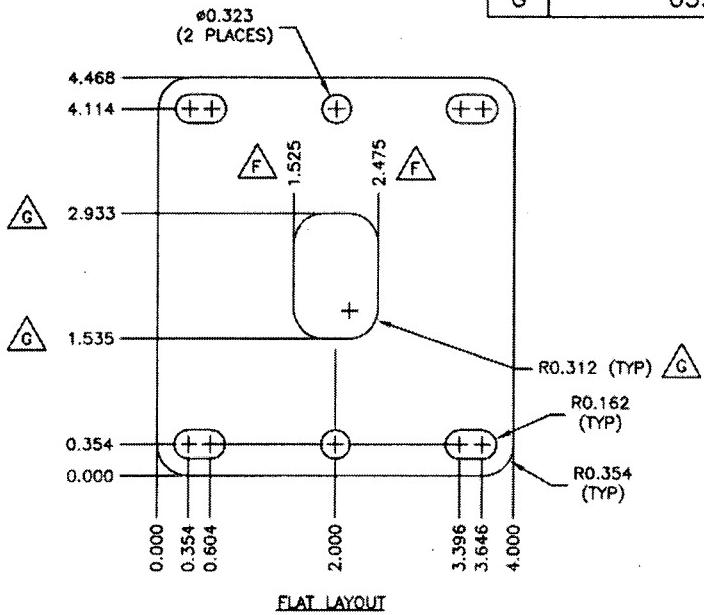
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 304SS sheet .080		Purchased	No			100	sf	141.4500	0.125	(3)		Jpn3-10-22	

Location	Loc Qty	Loc Code
MAT020	141.45	
117933	4.5	
119276	9.7	
M126075	127.25	126075

DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	108575
Description: Jack Saddle	Part Number:	-D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

- DAS

Measured by:	Jn	Audited by:	27 9-89	Prototype Approval:	N/A
Date:	13-10-22	Date:	B.10.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	SJL